

DART AEROSPACE LTD

Work Order:

22493

Description: Bearpaw Kit (19" x 24")

Part Number:

K10008

Dwg: D2432 Rev. F3

Qty:

3 ~~15~~ Kits

Ref: K10008 Rev. E; DSK086-5 Rev. A

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	HA	05.02.21	15
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	HA	05.04.05	3
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M15426	ML	05/03/11	6/6
4	MV	Inspect material for defects or damage prior to machining	ML	05/03/11	6/6
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	ML	05/03/11	14
6	QC2	Inspect parts as they come off the CNC machine	ML	05/03/11	14
7	MV	Deburr	ML	05/03/11	14
8	QC8 & 5	Second inspection	TE	05/03/11	14
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) Qty Part Number Description Batch 6 D2182B050 Rubber Cushion B20434/B 19540/B 21185/B 22505 12 D2274 Radius Block B20927/B 21585/B 21846 2 D2432F 24" Bearpaw B22493 6 D2438 Clamp B21189 12 D2529 Washer B21587A 6 D2732-050 Rubber Cushion B20433/B 22505 12 AN4-15A Bolt M15321 12 AN4-17A Bolt M14526 24 AN960JD416 Washer M15993 12 MS21042L4 Nut (or -4) M15020 1 Paperwork package from Step 2	CL	05/03/11	3
10	QC4	Inspect Kit for 100% Completeness on the W/O	SB	05/03/28	3
11	PK	Identify and pack for shipping as per PPP K10008	CL	05/03/28	3
12	AC	Cost / part 168.15	5ar	05-03-29	3
13	DC	Close W/O 229.21 Inspect Level 21	HA	05.04.05	3

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	#

BL 05-03-30

REFACER





PART AEROSPACE LTD		Work Order:	224936
Description: Bearpaw		Part Number:	D2432F
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060	✓	Vern	
B	5.500	+/-0.030	5.500	✓	Vern	
C	0.200	+/-0.030	0.203	✓	Vern	
D	0.25 x 45°	+/-0.030	0.230x45°	✓	Vern	
E	R0.250	+/-0.030	R0.250	✓	R-G	
F	0.250	+/-0.010	0.254	✓	Vern	
G	0.625	+/-0.030	0.612	✓	Vern	
H	0.375	+/-0.010	0.382	✓	Vern	
I	0.950	+0.030/0.010	0.960	✓	Vern	
J	19.000	+/-0.030	19.000	✓	M-Tape	
K	3.14	+/-0.030	3.126	✓	Vern	
L	3.28	+/-0.030	3.270	✓	Vern	
M	Ø0.260	+0.005/-0.000	Ø0.260	✓	Vern	
N	Ø0.93	+/-0.030	Ø.929	✓	Vern	
O	0.30	+0.030/-0.000	0.305	✓	Vern	
P	23.750	+/-0.030	23.750	✓	M-Tape	
Q	7.375	+/-0.030	7.375	✓	<del>Vern</del> M-Tape	
R	4.250	+/-0.010	4.250	✓	M-Tape	
S	2.000	+/-0.030	2.000	✓	Vern	
T	9.000	+/-0.010	9.000	✓	M-Tape	
U	9.000	+/-0.010	9.000	✓	M-Tape	
V	0.375	+/-0.010	0.380	✓	Vern	

Measured by: <i>me</i>	Audited by: <i>SA</i>	Prototype Approval:	N/A
Date: 05/03/07	Date: 05/03/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

RELEASED

# 04.01.15

